IN THE CLAIMS:

1. (Currently Amended) A process ~~Process~~ for preparing a ~~said~~ winding roll ~~(8)~~ for a flying roll change by arranging an ~~a said~~ adhesive tape ~~(44)~~ between the ~~said~~ beginning ~~(30.1)~~ of the web and a ~~said~~ web layer ~~(66)~~ of the ~~said~~ winding roll ~~(8)~~, which said web layer lies under it, ~~in which~~ the process comprising:

~~a)~~ lifting the beginning of the web ~~is lifted~~ off from the ~~said~~ winding roll ~~(8)~~; ;

~~b)~~ placing the ~~said~~ adhesive tape ~~(44) is placed~~ with a ~~said~~ first bonding surface ~~(62)~~ on the area of the ~~said~~ web that has remained wound up; ;

~~c)~~ cutting the ~~said~~ beginning ~~(30.1)~~ of the web ~~is cut~~ to size; ; and

~~d)~~ returning the ~~said~~ beginning ~~(30.1)~~ of the web, which has been lifted off and cut to size, ~~is returned~~ onto the ~~said~~ winding roll ~~(8)~~, so that a ~~said~~ second bonding surface ~~(63)~~ of the ~~said~~ adhesive tape ~~(44)~~ comes into contact with the ~~said~~ beginning ~~(30.1)~~ of the web.

2. (Currently Amended) A process ~~Process~~ for preparing a ~~said~~ winding roll ~~(8)~~ for a flying roll change by arranging a ~~said~~ adhesive tape ~~(44)~~ between the ~~said~~ beginning ~~(30.1)~~ of a web and a ~~said~~ layer ~~(66)~~ of the ~~said~~ winding roll ~~(8)~~ lying under it, in which:

~~a)~~ lifting the ~~said~~ beginning of the web ~~is lifted~~ off from the ~~said~~ winding roll ~~(8)~~;

~~b)~~ placing the ~~said~~ adhesive tape ~~(44) is placed~~ on the web;

~~c)~~ cutting the ~~said~~ beginning ~~(30.1)~~ of the web ~~is cut~~ to size;

~~wherein~~

~~d)~~ leading the ~~said~~ beginning of the web is led over a ~~said~~ roller ~~(10)~~ for cutting the

~~said~~ beginning ~~(30.1)~~ of the web to size; and

~~c)~~ pressing a ~~said~~ cutting knife ~~(51)~~ ~~is pressed~~ against the ~~said~~ roller ~~(10)~~ , so that a cutting blade of the ~~said~~ cutting knife ~~(51)~~ is pressed against the circumferential surface of the ~~said~~ roller ~~(10)~~ and the web is severed.

3. (Currently Amended) A process ~~Process~~ in accordance with claim 1 ~~or 2~~, ~~characterized in that~~ wherein the ~~said~~ beginning of the web is led over a ~~said~~ roller ~~(10)~~ that is in contact with the ~~said~~ winding roll ~~(8)~~.

4. (Currently Amended) A process ~~Process~~ in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein the shape of the edge of the ~~said~~ beginning ~~(30.1)~~ of the web is variable by using ~~said~~ cutting knives ~~(51)~~ of different designs to cut the web to size.

5. (Currently Amended) A process ~~Process~~ in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein the ~~said~~ lifted-off beginning of the web is cut to size over such a length, measured from the point of lift-off to the edge of the web, that the ~~said~~ beginning ~~(30.1)~~ of the web covers only a ~~said~~ predetermined part ~~(63.1)~~ of the ~~said~~ second bonding surface after returning to the ~~said~~ winding roll ~~(8)~~.

6. (Currently Amended) A process ~~Process~~ in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein the ~~said~~ beginning ~~(30.1)~~ of the web is wound off by

rotating the ~~said~~ roller ~~(10)~~ and/or the ~~said~~ winding roll ~~(8)~~ onto the ~~said~~ second bonding surface ~~(63)~~ without the ~~said~~ roller ~~(10)~~ touching the ~~said~~ bonding surface ~~(63)~~.

7. (Currently Amended) A process ~~Process~~ in accordance with ~~one of the above claims~~ claim 1, ~~characterized in that~~ wherein the steps of lifting, placing, cutting and returning ~~it is~~ are carried out fully automatically.

8. (Currently Amended) A device ~~Device~~ for lifting the beginning of a web off from a winding roll, placing adhesive tape on the web and cutting the beginning of the web to size ~~carrying out the process in accordance with one of the claims 1 through 7, which has~~, the device comprising:

~~a)~~ a ~~said~~ gripping device ~~(25)~~ for lifting off the ~~said~~ beginning of a web of the ~~said~~ winding roll ~~(8)~~;

~~b) a said~~ an adhesive tape applicator ~~(45)~~ for placing ~~a said~~ an adhesive tape ~~(44)~~ on the web of the ~~said~~ winding roll, ~~(8); wherein c)~~ the ~~said~~ adhesive tape applicator ~~(45) is~~ being arranged such that the ~~said~~ adhesive tape ~~(44)~~ can be placed on an area of the web on the jacket surface of the ~~said~~ winding roll ~~(8)~~, which said web area has remained wound up, and from which the beginning of the web was lifted off.

9. (Currently Amended) A device ~~Device~~ in accordance with claim 8 further comprising ~~with~~ a ~~said~~ cutting device for cutting the ~~said~~ beginning of the web to size, wherein

the ~~said~~ cutting device ~~preferably~~ has a ~~said~~ cutting knife ~~(51)~~ and a ~~said~~ drive means ~~(52)~~ and is arranged in relation to a ~~said~~ roller ~~(10)~~ , which adjoins the ~~said~~ winding roll ~~(8)~~ and via which the lifted-off web of the ~~said~~ winding roll ~~(8)~~ can be deposited, such that the ~~said~~ cutting knife ~~(51)~~ can be driven in the direction of the ~~said~~ roller ~~(10)~~.

10. (Currently Amended) A device ~~Device~~ in accordance with claim ~~8 or~~ 9, ~~characterized in that~~ wherein the arrangements of the ~~said~~ adhesive tape applicator ~~(45)~~ , the ~~said~~ cutting device and the ~~said~~ roller ~~(10)~~ in relation to the ~~said~~ winding roll ~~(8)~~ are coordinated with one another such that the cutting site of the ~~said~~ beginning ~~(30.1)~~ of the web and the web area with the ~~said~~ adhesive tape ~~(44)~~ on the ~~said~~ winding roll ~~(8)~~ are in a predetermined relationship to each other.

11. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the claims 8, 9 and 10~~ claim 9, ~~characterized in that~~ wherein the ~~said~~ adhesive tape applicator ~~(45)~~ , the ~~said~~ roller ~~(10)~~ and/or the ~~said~~ cutting knife ~~(51)~~ are pivotable.

12. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the claims 8 through 11~~ claim 9, ~~characterized in that~~ wherein the ~~said~~ cutting knife ~~(51)~~ of the ~~said~~ cutting device is replaceable.

13. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above claims~~

~~5 through 11~~ claim 9, ~~characterized in that~~ wherein a plurality of said cutting knives ~~(51)~~ with different blades shapes are provided in the ~~said~~ cutting device.

14. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above claims~~ claim 8, ~~characterized in that~~ wherein ~~it operates~~ the gripping device and the adhesive tape applicator operate fully automatically.

15. (Currently Amended) A device ~~Device~~ for gripping a ~~said~~ part ~~(65)~~ of a material web, the device comprising:

~~with~~ a ~~said~~ first element ~~(26)~~ ; and

a ~~said~~ second element ~~(28)~~ , which can be moved in relation to ~~one another~~ the first element, wherein a part of the ~~said~~ first element ~~(26)~~ can be placed on the ~~said~~ material web ~~(65)~~ and the ~~said~~ second element ~~(28)~~ can mesh with the ~~said~~ material web ~~(65)~~, so that the ~~said~~ material web ~~(65)~~ can be gripped between the ~~said~~ first element ~~(26)~~ and the ~~said~~ second element ~~(28)~~ by a relative movement between the ~~said~~ first element ~~(26)~~ and the ~~said~~ second element ~~(28)~~ .

16. (Currently Amended) A device ~~Device~~ in accordance with claim 15, wherein the ~~said~~ material web ~~(65)~~ is wound up on a ~~said~~ winding roll ~~(8)~~.

17. (Currently Amended) A device ~~Device~~ in accordance with claim 15 ~~or 16~~, wherein

the ~~said~~ first element ~~(26)~~ is a rotatable ~~element, especially a~~ roller element.

18. (Currently Amended) A device ~~Device~~ in accordance with claim 15 ~~or 16~~, wherein the ~~said~~ first element is a gripping element, which can be placed on the ~~said~~ material web ~~(65)~~.

19. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above four claims~~ claim 15, wherein the ~~said~~ first element ~~(26)~~ and/or the ~~said~~ second element ~~(28)~~ have at least one opening to mesh with each other.

20. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above five claims~~ claim 15, wherein the ~~said~~ first element ~~(26)~~ and/or the ~~said~~ second element ~~(28)~~ can be driven, so that a relative movement can be generated between the ~~said~~ first and second elements and/or a relative movement can be generated between the ~~said~~ first element ~~(26)~~ and the ~~said~~ material web ~~(65)~~ or between the ~~said~~ second element ~~(28)~~ and the ~~said~~ material web ~~(65)~~.

21. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above six claims~~ claim 15, wherein the ~~said~~ first element and/or the ~~said~~ second element have ~~a said~~ an elastic element (110) to meter the contact or pressing pressure on the ~~said~~ material web ~~(65)~~.

22. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above seven~~

~~claims~~ claim 15, wherein the ~~said~~ second element ~~(28)~~ has ~~a said~~ an edge ~~(28a)~~, which can mesh with the ~~said~~ material web ~~(65)~~.

23. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above eight claims wherein~~ claim 15, further comprising: a ~~said~~ sensor ~~(31) is provided~~ for detecting a feature of the ~~said~~ material web ~~(65)~~.

24. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above claims wherein~~ claim 23, further comprising: a control ~~is provided, which controls~~ controlling the relative movement between the ~~said~~ first element ~~(26)~~ and/or the ~~said~~ second element ~~(28)~~ and/or the ~~said~~ material web ~~(65), preferably with the use of~~ using the signal detected by the ~~said~~ sensor ~~(31)~~.

25. (Currently Amended) A system ~~System~~ for gripping a part of a ~~said~~ material web ~~(65)~~, the system comprising:

~~with~~ a ~~said~~ material web holding device ~~(8)~~;;

a device for gripping the ~~said~~ material web with a first element and a second element, which can be moved in relation to the first element, wherein a part of the first element can be placed on the material web and the second element can mesh with the material web, so that the material web can be gripped between the first element and the second element by a relative movement between the first element and the second element; ~~in accordance with one of the~~

~~above 10 claims~~, and

~~with~~ a ~~said~~ moving element ~~(27, 103)~~ to move the device for gripping the ~~said~~ material web in relation to the ~~said~~ material web holding device ~~(8)~~.

26. (Currently Amended) A system ~~System~~ in accordance with claim 25, wherein the ~~said~~ material holding device ~~(8)~~ is moved in relation to the ~~said~~ device for gripping the ~~said~~ material web.

27. (Currently Amended) A system ~~System~~ in accordance with claim 25 ~~or 26~~, wherein the ~~said~~ device for gripping the ~~said~~ material web is moved in relation to the ~~said~~ material web holding device ~~(8)~~.

28. (Currently Amended) A process ~~Process~~ for gripping a ~~said~~ material web ~~(65)~~, the process comprising the steps of: ~~wherein~~

placing a ~~said~~ first element ~~(26) is placed~~ on the ~~said~~ material web ~~(65)~~; ;

bringing a ~~said~~ second element ~~(28) is brought~~ into meshing with the ~~said~~ material web ~~(65)~~; ; and

holding the ~~said~~ material web ~~(65) is held~~ between the ~~said~~ first element ~~(26)~~ and the ~~said~~ second element ~~(28)~~ by a relative movement between the ~~said~~ first element ~~(26)~~ and the ~~said~~ second element ~~(28)~~.

29. (Currently Amended) A process ~~Process~~ in accordance with claim 28, wherein the ~~said~~ gripped material web is picked up by a movement of the ~~said~~ first and second elements ~~(26, 28)~~ holding the ~~said~~ material web ~~(65)~~.

30. (Currently Amended) A device ~~Device~~ for placing a ~~said~~ double-sided adhesive tape ~~(44)~~ on a ~~said~~ surface, the device comprising: ~~(66)with a said~~

an adhesive tape feeding device ~~(205)~~ for feeding the ~~said~~ double-sided adhesive tape ~~(44)~~ masked with at least one ~~said~~ masking tape; ~~(64), with~~

a ~~said~~ separating device ~~(212)~~ for separating the ~~said~~ double-sided adhesive tape ~~(44)~~ from the at least one said masking tape; ~~(64), with~~

a ~~said~~ cutting device ~~(220, 221)~~ for cutting the ~~said~~ double-sided adhesive tape; and ~~(44), and with a said~~

an adhesive tape pressing device ~~(219)~~ for bringing together and/or pressing on the ~~said~~ double-sided adhesive tape ~~(44)~~, wherein the ~~said~~ at least one masking tape ~~(64)~~ is led between the ~~said~~ adhesive tape pressing device ~~(219)~~ and the ~~said~~ double-sided adhesive tape ~~(44)~~ which is to be pressed on.

31. (Currently Amended) A device ~~Device~~ in accordance with claim 30, wherein the ~~said~~ adhesive tape feeding device ~~(105)~~ is a roller.

32. (Currently Amended) A device ~~Device~~ in accordance with claim 30 ~~or 31~~, wherein

the ~~said~~ separating device ~~(212)~~ for separating the ~~said~~ double-sided adhesive tape ~~(44)~~ from the ~~said~~ at least one masking tape ~~(64)~~ is a roller or a stationary element.

33. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above three claims~~ claim 30, wherein the ~~said~~ adhesive tape pressing device ~~(219)~~ is a roller or a stationary element.

34. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above four claims~~ claim 30, wherein a ~~said~~ movable or pivotable element ~~(216)~~ is provided to pick up a variable length of the ~~said~~ masking tape ~~(64)~~.

35. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above five claims~~ claim 30, wherein the ~~said~~ cutting device ~~(220, 221)~~ is arranged between the ~~said~~ separating device ~~(212)~~ and the ~~said~~ adhesive tape pressing device ~~(219)~~.

36. (Currently Amended) A device ~~Device~~ in accordance with ~~one of the above six claims~~ claim 30, ~~wherein~~ further comprising: a ~~said~~ masking tape pick-up device ~~(224) is~~ provided for taking up the ~~said~~ masking tape ~~(64)~~.

37. (Currently Amended) A system ~~System~~ with a device in accordance with ~~one of the above seven claims and with~~ claim 30, further comprising: a ~~said~~ moving unit ~~(43)~~ for

generating a relative movement between the device for applying the ~~said~~ double-sided adhesive tape ~~(44)~~ and the ~~said~~ surface ~~(66)~~ .

38. (Currently Amended) A process ~~Process~~ for placing a ~~said~~ double-sided adhesive tape ~~(44)~~ on a ~~said~~ surface ~~(66)~~, the process comprising: ~~wherein~~

pulling a ~~said~~ masking tape ~~(64)~~ covering the ~~said~~ double-sided adhesive tape ~~(44) is pulled~~ off from the ~~said~~ double-sided adhesive tape ~~(44)~~; ;

severing the ~~said~~ adhesive tape ~~(44) is severed~~ after a predetermined length; ; and

pressing the ~~said~~ double-sided adhesive tape ~~(44) is pressed~~ onto the surface by a pressure applied on the ~~said~~ masking tape ~~(64)~~ which has been returned.

39. (Currently Amended) A process ~~Process~~ in accordance with claim 38, wherein the ~~said~~ double-sided adhesive tape ~~(44)~~ is applied to the ~~said~~ surface ~~(66)~~ piece by piece.

40. (New) A process in accordance with claim 2, wherein the beginning of the web is led over a roller that is in contact with the winding roll.

41. (New) A process in accordance with claim 2, wherein the shape of the edge of the beginning of the web is variable by using cutting knives of different designs to cut the web to size.

42. (New) A process in accordance with claim 2, wherein the lifted-off beginning of the web is cut to size over such a length, measured from the point of lift-off to the edge of the web, that the beginning of the web covers only a predetermined part of the second bonding surface after returning to the winding roll.

43. (New) A process in accordance with claim 2, wherein the beginning of the web is wound off by rotating the roller and/or the winding roll onto the second bonding surface without the roller touching the bonding surface.

44. (New) A process in accordance with claim 2, wherein the steps of lifting, placing, cutting, leading and pressing are carried out fully automatically.